

March-28-12 2:32:05 PM

82302

Page 1

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

16

Cust Item ID:

16

Customer:

Reference:

Approvals:

Process Plan: MLT

Date: 12/03/20 Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

[illegible]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 82302

82302

Page 2

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Item ID: D3401-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Tow Cap Assembly
 Start Date: 28/03/2012 Start Qty: 16.00 ***16*** Cust Item ID:
 Required Date: 04/04/2012 Req'd Qty: 16.00 ***16*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	HAAS CNC VERTICAL MACHINING #1	0.00							
130									
HAAS I	Memo	0.00							
HAAS CNC vertical machine #1	Machine as per Folio FA532 and Dwg D3401 Dwg Rev: <u>B</u> Folio Rev: <u>AA</u> Identify as D3401-1 Deburr & Buff rad as per Dwg D3401		PD/B.A	12/04/09					
			SL	12/04/10					
135	QC2- Inspect parts off machine FAI/FAIB	0.00							
135									
QC	Memo	0.00							
Quality Control			PD/B.A	12/04/09					
			SL	12/04/10					
140	QC8- Inspect parts - second check	0.00							
140									
QC	Memo	0.00							
Quality Control			SL	12/04/10					

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 82302***82302***

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Item ID: D3401-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Tow Cap Assembly

Start Date: 28/03/2012 Start Qty: 16.00

16

Cust Item ID:

Required Date: 04/04/2012 Req'd Qty: 16.00

16

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

150

Small Fab

Small Fab

Memo

0.00

0.00

Drill and c/sink using DT8782 as per Dwg D3401

16

Ø

FF

12/04/11

160

160

QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

Sizelue/3

(16)

170

170

HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

Memo

0.00

0.00

(16) NG

12-4-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 82302

82302

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Item ID: D3401-041
 Revision ID:
 Item Name: Tow Cap Assembly
 Start Date: 28/03/2012 Start Qty: 16.00
 Required Date: 04/04/2012 Req'd Qty: 16.00
 Reference:

Accept

N900040100

Setup Start ***NS1***
 Stop ***NS2***

Cust Item ID:
 Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 *180* Powdercoat Powder Coating <i>M121134</i>	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Memo START TIME: <i>7:30</i> OVEN TEMPERATURE: <i>320 OF</i> FINISH TIME: <i>8:00</i>	0.00 0.00				<i>16x</i>	<i>0</i>		<i>M-L</i> <i>12/04/17</i>
190 *190* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				<i>16</i>	<i>0</i>		<i>BL 12-4-17</i>
195 *195* HandFinish Hand Finishing	Assemble as per dwg Memo	0.00 0.00				<i>16x</i>	<i>0</i>		<i>Ill 12/04/17</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Work Order ID 82302




82302

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March-28-12 2:32:05 PM

Item ID: D3401-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Tow Cap Assembly
 Start Date: 28/03/2012 Start Qty: 16.00 ***16*** Cust Item ID:
 Required Date: 04/04/2012 Req'd Qty: 16.00 ***16*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200 *200* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							
210 *210* Packaging Packaging	Identify as per dwg & Stock Location: <u>FP-2</u> Memo	0.00 0.00				<u>X16</u>	<u>0</u>		<u>del w/ab</u>
220 *220* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							<u>12/4/17</u>  <u>mk</u> <u>12-04-17</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

2/5/1

Picklist Print

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Page 1

Work Order ID: 82302

82302

Parent Item: D3401-041

D3401-041

Parent Item Name: Tow Cap Assembly

Start Date: 28/03/2012

Required Date: 04/04/2012

Start Qty: 16.00

Required Qty: 16.00

Comments: IPP A05.09.01New issueKJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

NAS1330C3KB116 Purchased No

100

Each

546.0000

4

64

NAS1330C3KB116

**

Insert

Location

Loc Qty

Loc Code

ST276

546

102606

108

103337

438

M6061T6R3.500

Purchased

No

200

f

12.0000

0.35

5.894737

M6061T6R3 500

**

6061 RD bar 3.50

Location

Loc Qty

Loc Code

MAT036

12

120708

12

119231

8.6

12.3.30

865

11/04/17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

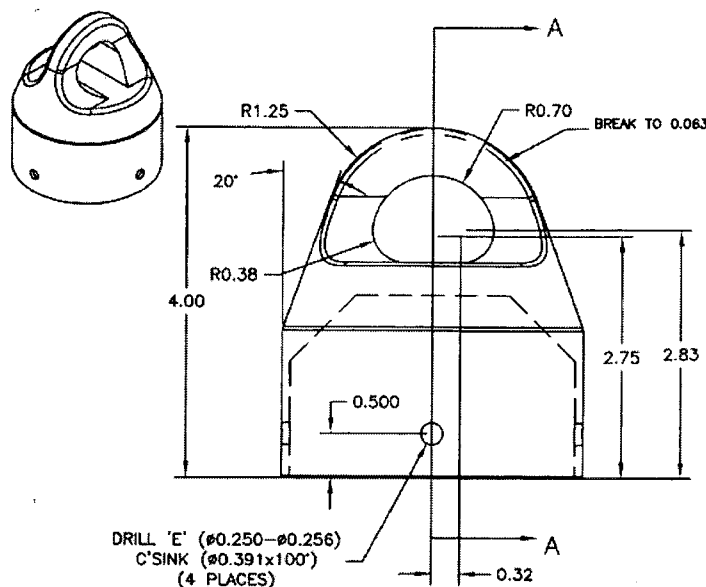
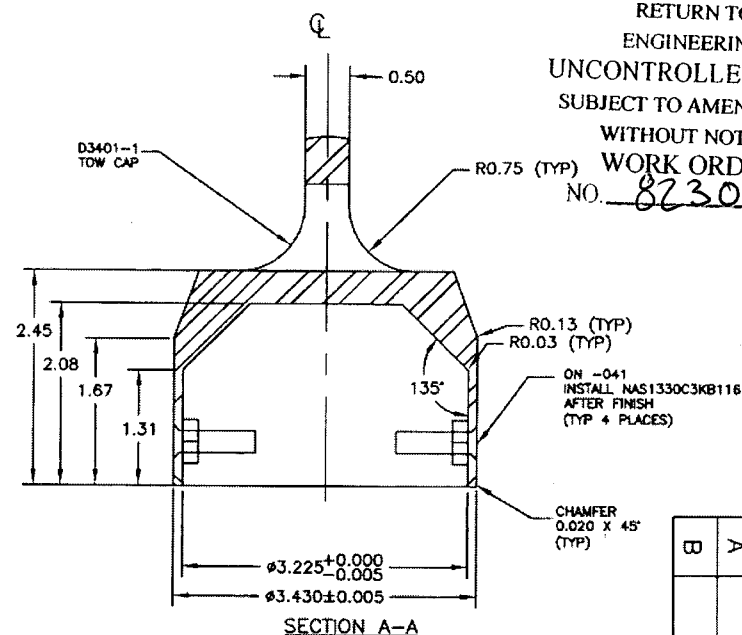
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

SHOP COPY

RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 82302

**D3401-1 TOW CAP****D3401-1/-041 TOW CAP****D3401-1 TOW CAP**

- 1) MATERIAL: MAKE FROM ALUMINUM 6061-T6 ϕ 3.500 ROUND BAR
PER QQ-A-225/8 OR AMS-QQ-A-200/8
(REF. DART SPEC M6061T6R3.5000)
- 2) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.015
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

D3401-041 TOW CAP

- 1) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3

D3401-041 TOW CAP PARTS LIST

QTY	PART NUMBER	DESCRIPTION
1	D3401-1	TOW CAP
4	NAS1330C3KB116	INSERT

DESIGN	PH	DRAWN BY	PH	DART AEROSPACE USA, INC.
CHECKED		APPROVED		PORT HADLOCK, WA
DATE	05.06.09	TITLE	D3401	SHEET 1 OF 1
			TOW CAP	SCALE 1:2
			CHAMFER INSIDE/REMOVE RADIUS	
			NEW ISSUE	
			05.02.24	
			05.06.09	

RELEASED
05-08-09

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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